

Work Order ID 72146

Tuesday, July 19, 2011 1:45:35 PM



Page 1

Item ID: D3407-5

Accept



Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 7/19/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 1/07-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp****Draw Nbr****Revision Nbr**

D3407

Rev E

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

17.4 250 x 4

Memo

1-Cut as per Dwg D3407

Dwg Rev: E

Prog Rev: E

2-Break edges on grinder as per Dwg D3407

→ Ac 11-08-16

TB11-8-3

68

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

Memo

0.00

TB11-8-3

68

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S w/ok 17

Counted
728

QC

Quality Control

130

Identify as per dwg & Stock Location: WPA

0.00

E2 11-8-17

X28



Packaging

Packaging

Memo

0.00

*****STOCK IN LARGE FAB*****

140

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

W18/18 JJ

11-08-17
28

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 1:45:43 PM

Page 1

Work Order ID: 72146



Parent Item: D3407-5



Parent Item Name: Ring

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 05-11-22 JLM
IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000 17-4 SS Bar .250 X 4.00		Purchased		No		100	f	13.5000	0.2666	5.612632	8		

Barcode for Component Item ID M174B0.250X4.000

Location	Loc Qty	Loc Code
MAT050	13.5	
118243	13.5	

118243

28

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72146
Description: Tow Ring	Part Number:	D3407-5
Inspection Dwg: D3407	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11-8-3</u>	Date: <u>11/05/162</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.02.02	New Issue	KJ/JLM	
B	07.09.18	Tolerance revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	09.05.04	Dwg Rev updated	KJ/DD	 

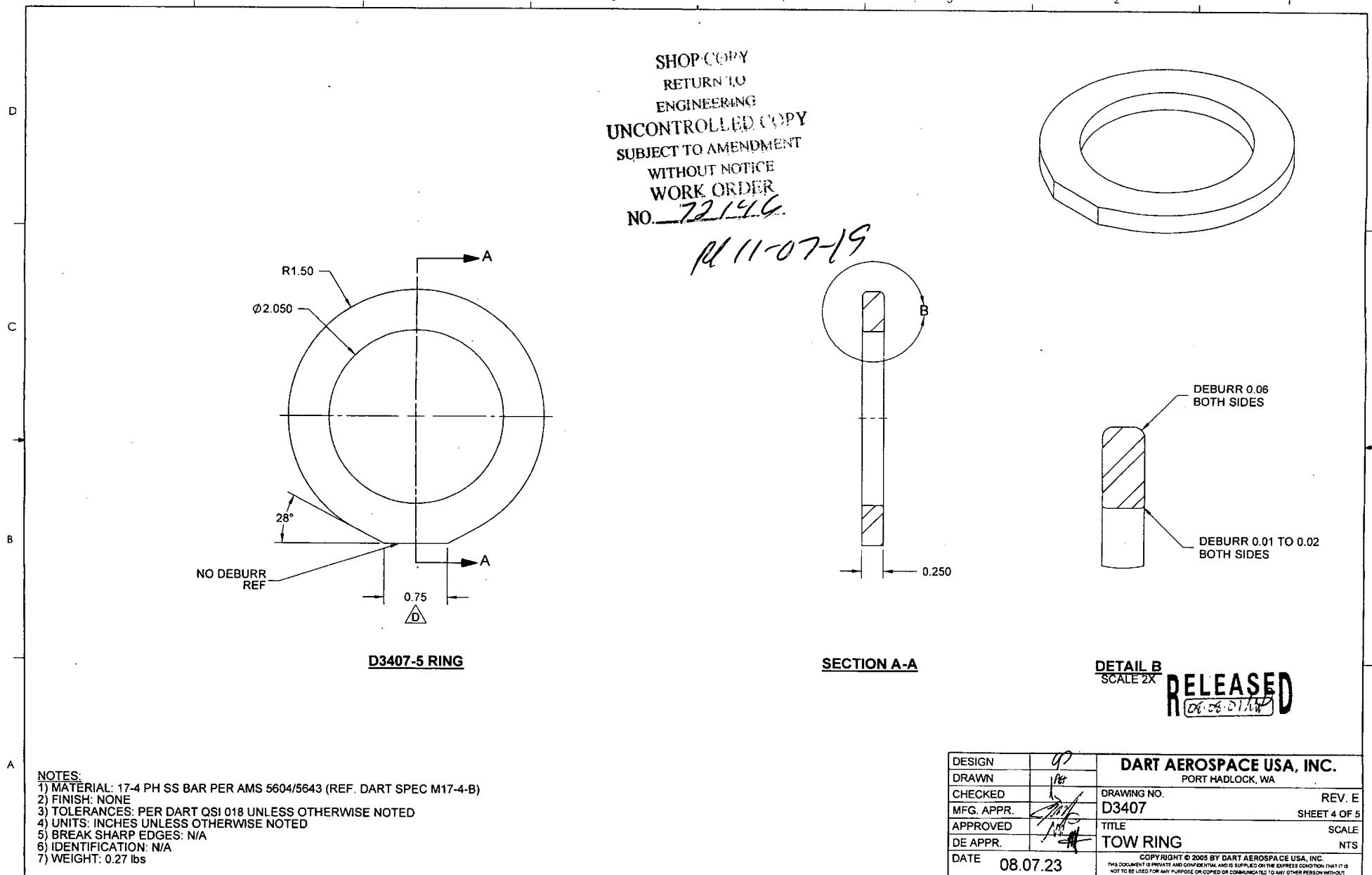
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



A

DESIGN	<i>97</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>18</i>	PORT HADLOCK, WA	
CHECKED	<i>18</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>18</i>	D3407	SHEET 4 OF 5
APPROVED	<i>18</i>	TITLE	SCALE
DE APPR.	<i>18</i>	TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:

WORK ORDER CHANGES

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